Garant

GARANT Master INOX M SlotMachine solid carbide roughing end mill HPC, TiAlN, ⌀ d11 DC: 12mm

Order data

Order number	205450 12
GTIN	4062406276102
Item class	11X

Description

Version:
With a **new type of knuckle form profile,** optimised for higher feed rates. Improved cutting edge protection thanks to slight edge honing. **Tremendous bending strength** due to the use of **ultra-fine grain substrate.** Number of cutters selected for performance and process reliability.
Advantage:
The tool geometry produces particularly tightly rolled swarf that is discharged via flat chip breaker recesses. As a result, the tool maintains an **extremely stable core.**
Application:
For roughing machining, particularly suitable for full-slot machining.
Recommendation:
To ensure reliable working, particularly for full slot milling, use arbors with **4 cooling channel bores**.

Technical description

Flute length L_c	26 mm
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.04 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in INOX > 900 N/mm^2	0.05 mm
Overhang length L_1 incl. recess	36 mm
No. of teeth Z	5
Tolerance nominal ⌀	d11

Corner chamfer width at 45°	0.25 mm
Overall length L	83 mm
Shank	DIN 6535 HB to h6
Helix angle	40 degrees
Recess Ø D_1	11.1 mm
Shank Ø D_s	12 mm
Corner chamfer angle	45 degrees
Cutting edge Ø D_C	12 mm
Series	Master INOX
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	NR
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable only under restricted conditions	150 m/min	P
Steel < 750 N/mm²	suitable	140 m/min	P
Steel < 900 N/mm²	suitable	120 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable	100 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M

INOX > 900 N/mm²	suitable	80 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable		